

Fig. 1

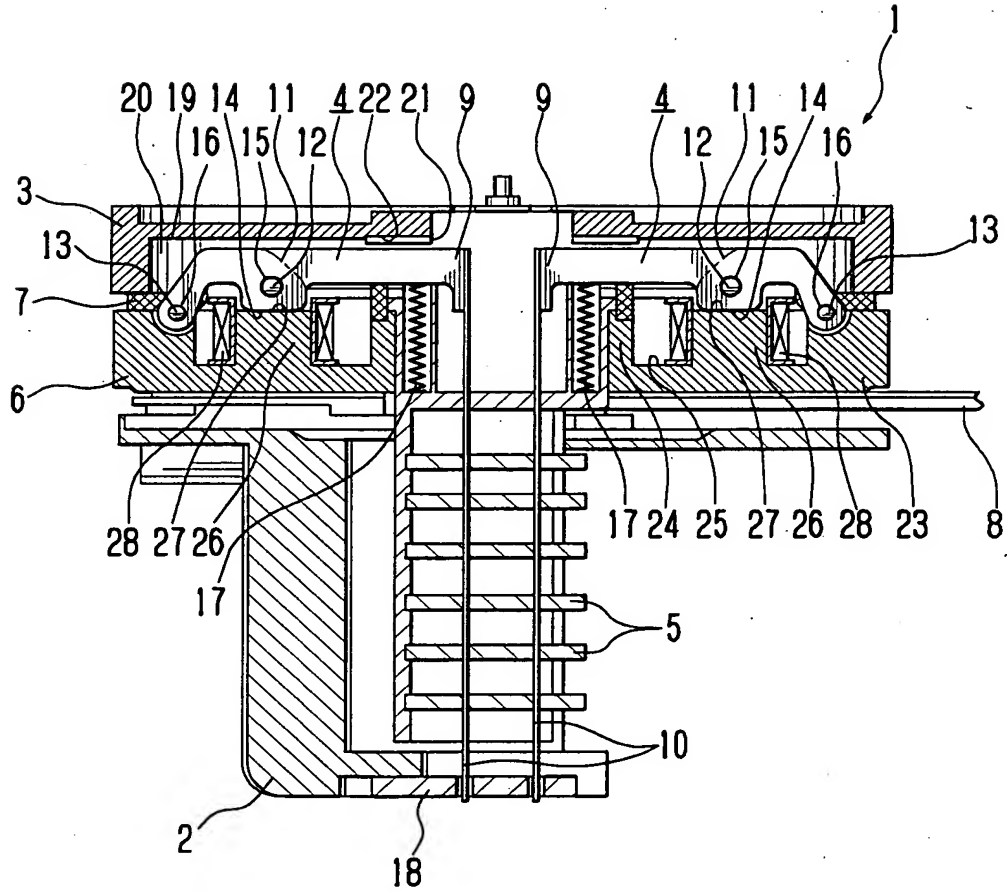


Fig. 2

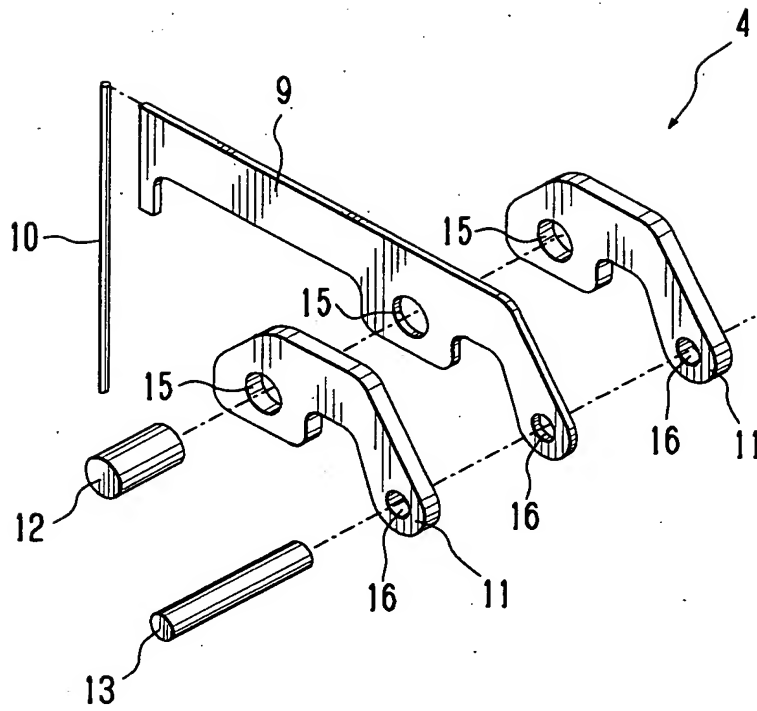


Fig. 3

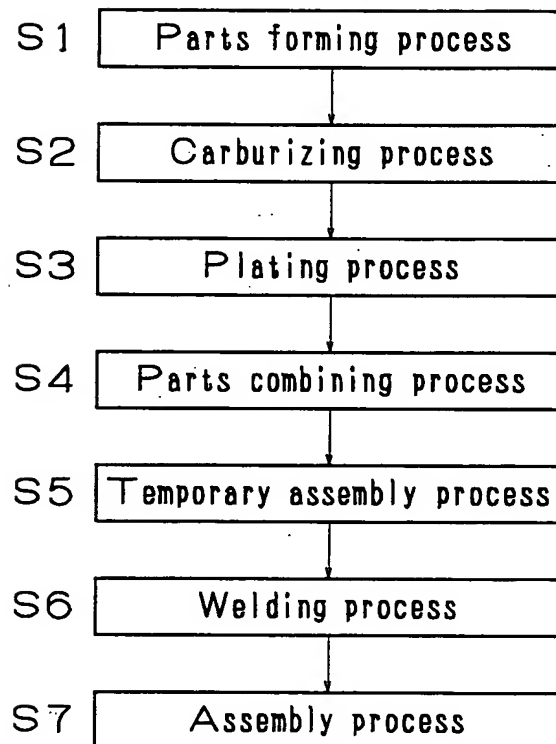


Fig. 4

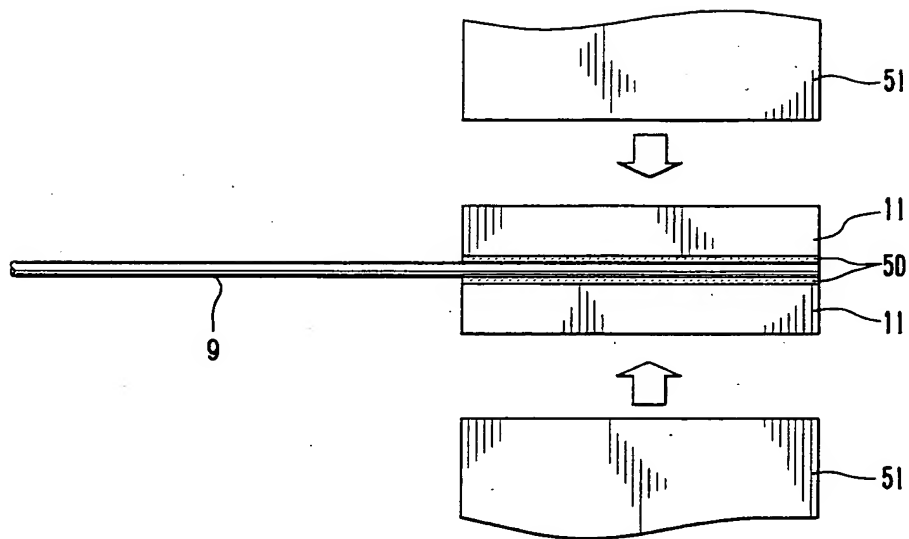


Fig. 5

	Welding current (A)	Pressure (kgf)	Size of electrodes (mm)	Waveform of welding current	Weld strength (kgf·cm)
Example	3600	24	4X6	1+7+5+9+2	5.8
Comparative example	3750	24	4X6	1+7+5+9+6	5.5

Fig. 6A

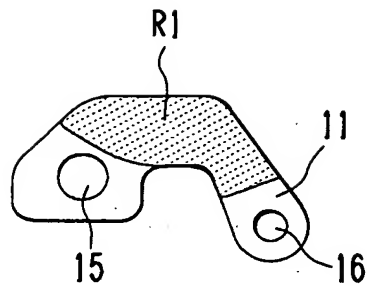


Fig. 6B

